

Work Order ID 60249

Tuesday, June 29, 2010 3:48:32 PM



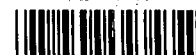
Page 1

Item ID: D3813-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Assembly, Lower Door

Start Date: 6/29/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date: 6/29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3813

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Install helicoils as per Dwg D3813 2-Install Ball joint and nut loosely as per Dwg D3813

7m-d 10/07/14



110

QC5- Inspect part completeness to step on W/O

0.00



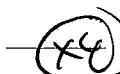
QC

Memo

0.00

Quality Control

S 10/07/14



120

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

10/14/14 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Page 2

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Accept

Setup Start

Revision ID:

Stop

Item Name: Hinge Assembly, Lower Door

Start Date: 6/29/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

100715
MF
10-7-14

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 29, 2010 3:48:36 PM

Page 1 / 1

Work Order ID: 60249

Parent Item: D3813-043

Parent Item Name: Hinge Assembly, Lower Door





Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 08-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																
D3518-3  Stainless Steel Ball Joint Rod End		Manufactured	No			100	Each	14.0000	1	4																			
<table><tr><td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td><td></td></tr><tr><td>ST067</td><td>14</td><td></td><td></td></tr><tr><td>39029</td><td>6</td><td></td><td></td></tr><tr><td>53454 ✓</td><td>8</td><td></td><td></td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		ST067	14			39029	6			53454 ✓	8		
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ST067	14																												
39029	6																												
53454 ✓	8																												
D3813-3  Hinge, Lower Door		Manufactured	No			100	Each	6.0000	1	4																			
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ST090	6																												
42053 ✓	1																												
53045 ✓	5																												
MS124738  Heli-Coil 3/8-24 unf		Purchased	No			100	Each	45.0000	1	4																			
<table><tr><td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td><td></td></tr><tr><td>ST314</td><td>45</td><td></td><td></td></tr><tr><td>113368 ✓</td><td>45</td><td></td><td></td></tr></table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		ST314	45			113368 ✓	45						
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ST314	45																												
113368 ✓	45																												
NAS509-6  Nut		Purchased	No			100	Each	20.0000	1	4																			
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ST280	20																												
113537 ✓	20																												

10/07/14

m.k

4X

10/07/14

m.k

1X
3X

10/07/14

m.k

4X

10/07/14

m.k

4X

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

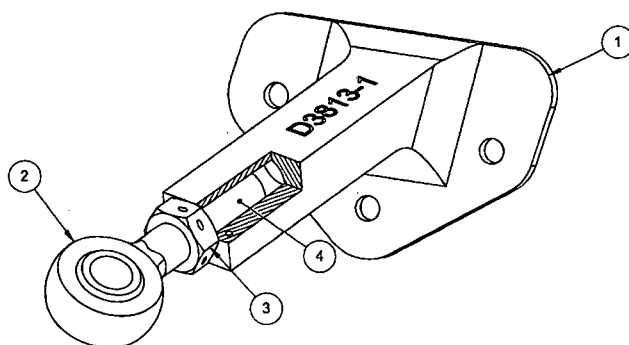
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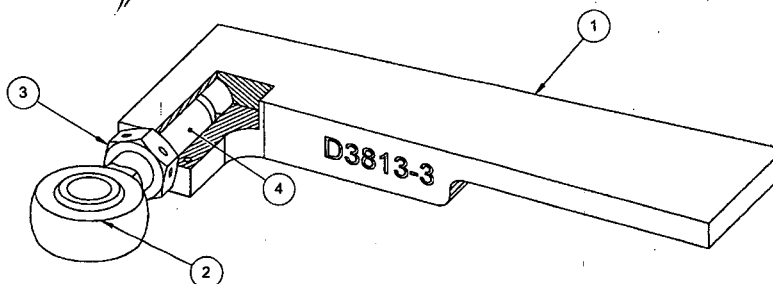
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *60249*
PS10629



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3813-1	HINGE, UPPER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

D3813-041 HINGE ASSY, UPPER DOOR



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -043
1	D3813-3	HINGE, LOWER DOOR	1
2	D3518-3	BALL JOINT ROD END	1
3	NAS509-6	NUT	1
4	MS124738	HELI-COIL, 3/8-24 UNF	1

D3813-043 HINGE ASSY, LOWER DOOR

RELEASED
01/01/3 AM

A	NEW ISSUE	DESCRIPTION	BY	DATE
REV.				
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.11.10			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3813	REV. A SHEET 1 OF 4
TITLE HINGE	SCALE NTS

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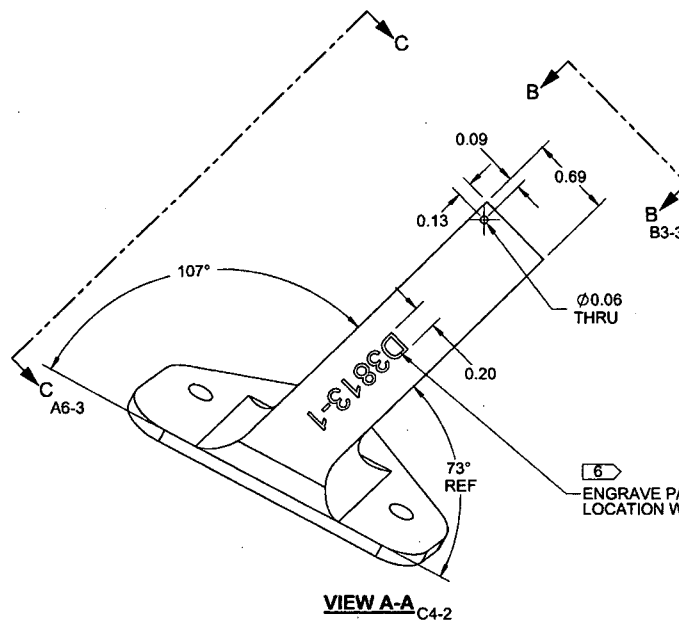
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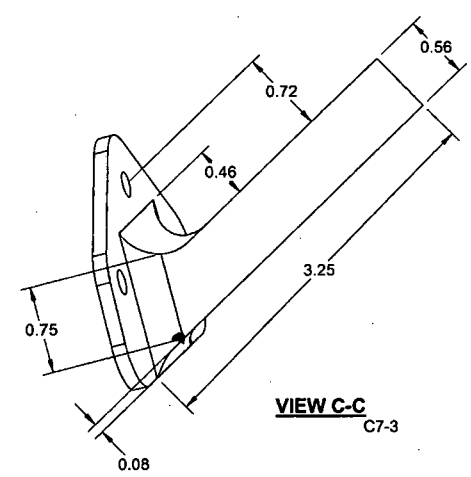
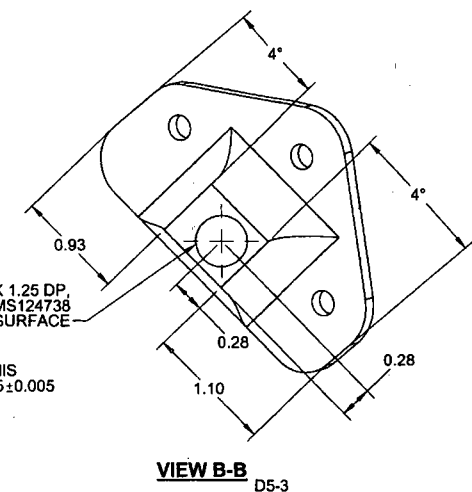
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Ø0.391 X 1.25 DP,
INSTALL HELICOIL MS124738
FLUSH WITH SURFACE

6
ENGRAVE P/N TO DEPTH OF 0.005 IN THIS
LOCATION WITH TOOL TIP RAD OF 0.015±0.005



D3813-1 HINGE, UPPER DOOR

w/b 60249

RELEASED
09/01/13

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3813	REV. A
MFG. APPR.			SHEET 3 OF 4
APPROVED		TITLE HINGE	SCALE
DE APPR.			NTS
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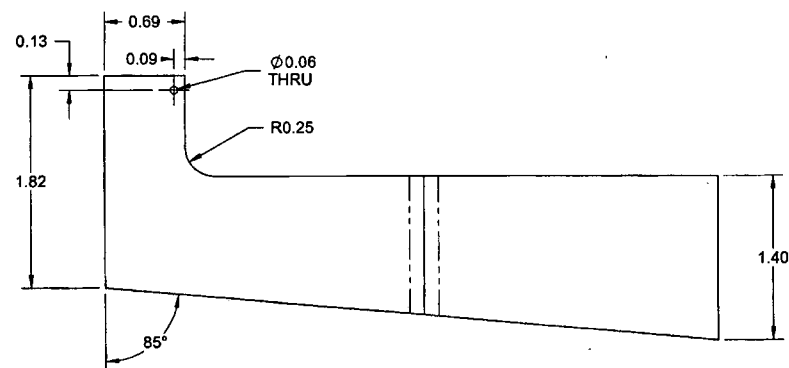
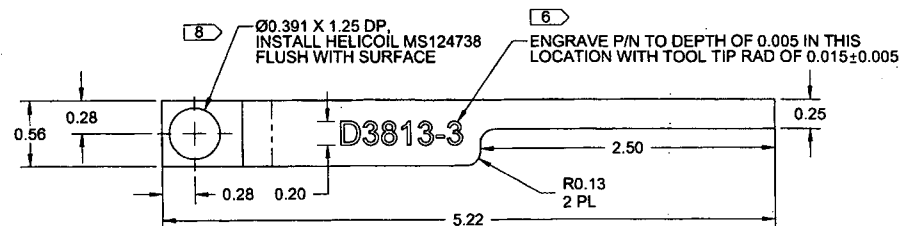
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D3813-3 HINGE, LOWER DOOR

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160), (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.020 TO 0.030 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.24 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN		DART AEROSPACE LTD
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CHECKED		DRAWING NO. REV. A
MFG. APPR.		D3813 SHEET 4 OF 4
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RELEASED
09/07/13 MJD

who 40249

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